

Work Order ID 78651

78651

Page 1

January-12-12 8:03:44 AM

Item ID: D4518-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Torsion Spring
 Start Date: 12/01/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4518	A

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>15863</u>								
	Manufacture as per D4518 Dwg								
	Possible supplier: Victoria Spring								
	Material release note is required.								

CH 12/01/12 50

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								

12/2/12 (50)

120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

8/2/12/12

count
(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78651

78651

Page 2

January-12-12 8:03:44 AM

Item ID: D4518-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Torsion Spring
 Start Date: 12/01/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>131F</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SP 12-02-08

12/2/12 48

u 12.02.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-12-12 8:03:48 AM

Page 1

Work Order ID: 78651

78651

Parent Item: D4518-1

D4518-1

Parent Item Name: Torsion Spring

Start Date: 12/01/2012

Required Date: 02/02/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP REV:A 12.01.11 new issue DD verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4518-1P		Purchased	No			110	Each	0.0000	1	50			
D4518-1P									**				
Torsion Spring													

11/4/12 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

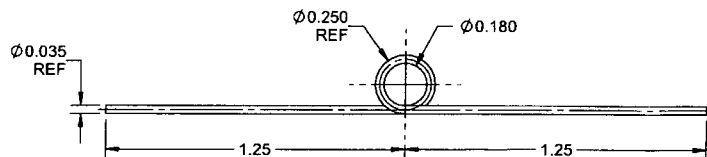
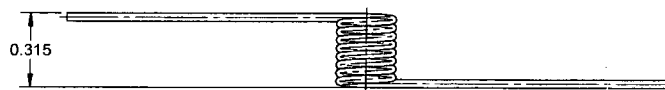
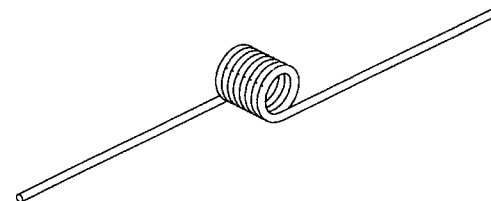
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



D4518-1 TORSION SPRING

SHOW ONLY
KEEP TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO IMPROVEMENT
WITHOUT NOTICE
WORK ORDER
NO. 78651 H.C.J.
12/01/12

RELEASED
2012-01-10
MM

NOTES:

- 1) MATERIAL: 301/304 STAINLESS STEEL SPRING WIRE, $\phi 0.035$, PER ASTM A666/A313
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: WITH DART P/N "D4518-1" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: LESS THAN 0.01 lbs

A	NEW ISSUE	DESCRIPTION	MB	11.12.05
REV.			BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO. D4518		REV. A
MFG. APPR.		TITLE		SHEET 1 OF 2
APPROVED		SPRING, LATCH		SCALE
DE APPR.				NTS
DATE	11.12.05	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

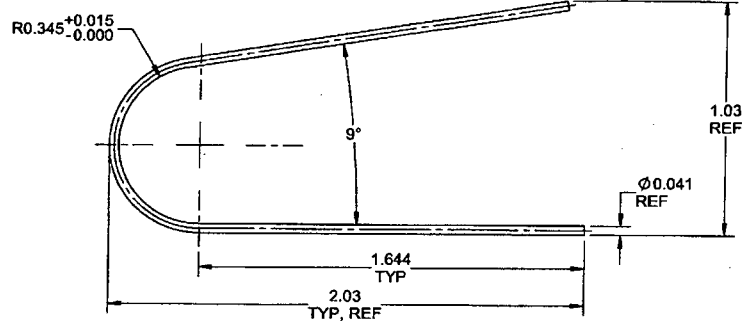
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

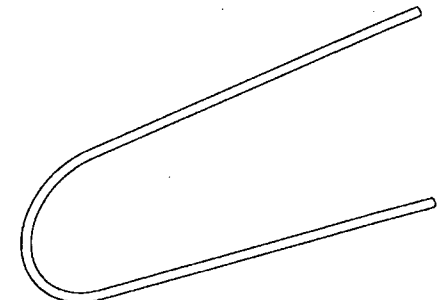
NOTE: Date & initial all entries

78651

SPECIFICATION CONTROL DRAWING



D4518-3 LOCK BARREL SPRING



RELEASE
2012-03-14

NOTES:

- 1) MATERIAL: 301/304 STAINLESS STEEL SPRING WIRE, $\varnothing 0.041$, PER ASTM A666/A313
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: WITH DART P/N "D4518-3" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: LESS THAN 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4518 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		SPRING, LATCH NTS
DATE	11.12.05	

COPYRIGHT © 2011 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO15863**

Purchase Order Date 1/12/12

PO Print Date 1/12/12

Page Number 1 of 1

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Contact Name

Vendor Phone

866 230 5312

Vendor Fax

866 230 5338

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

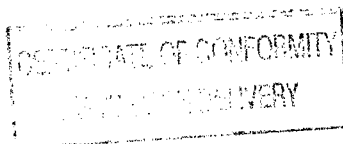
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 12/01/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4518-1P	Torsion Spring	2/08/12 Yes	50.00 Each	FedEx PI collect	\$4.5600	\$228.00
		Special Inst:	AS PER DWG D4518 REV. A B78651				
2	D4518-3P	Lock Barrel Spring	2/08/12 Yes	50.00 Each	FedEx PI collect	\$4.6000	\$230.00
		Special Inst:	AS PER DWG D4518 REV. A B78652				

PO Total:

\$458.00



Change Nbr:

1

Change Date: 1/12/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd	DATE: 2/7/2012
PART/DRAWING #: D4518-1P	PO # PO15863
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS 302	yes	
Material diameter	0.035	yes	
Coil I.D.	0.180	0.177	
Coil O.D.	0.25	0.247	
Number of Coils			8762/08
Free Length	0.315	0.312	
Helix	RHW	yes	
End type	1.25"	1.23 - 1.27	

COMMENTS

Mill Certificate attached:
Material Heat Number:

Inspected by: *Jeremy Burrows*